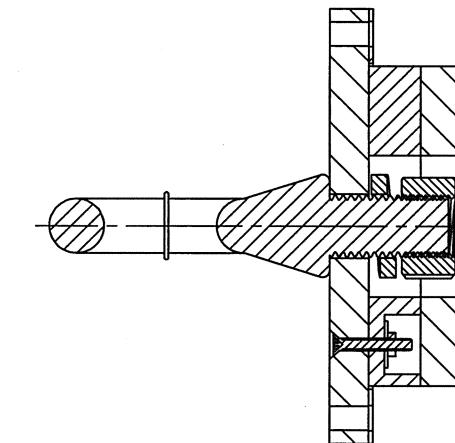
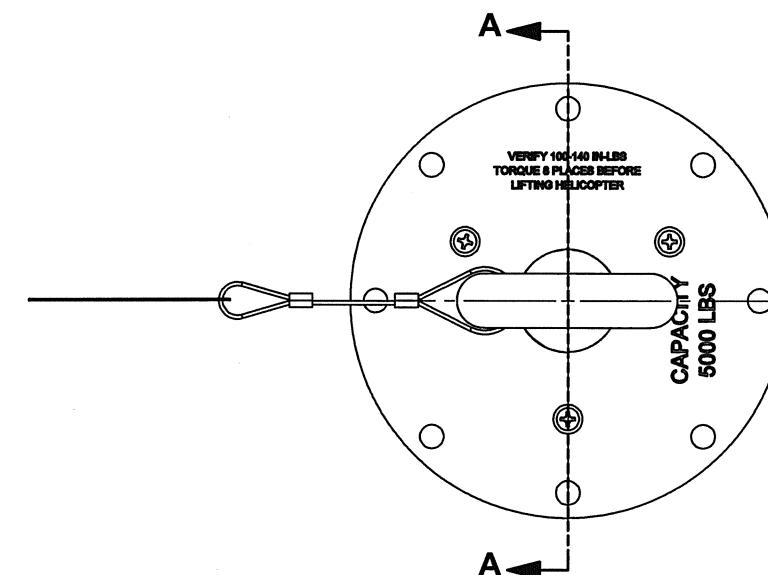


ITEM #	QTY	PART #	PART TITLE
-1	1	RBT400206-1	PLATE
-3	1	RBT400206-3	SPACER 1
-5	1	RBT400206-5	SPACER 2
-7	1	RBT400206-7	GASKET
-9	1	RBT400206-9	EYE BOLT MODIFIED
10	1	RB41011	DART PLACARD
11	1	McMaster#94895A038 OR EQUIV	GRADE 8 ZINC YELLOW PLATED STEEL HEX NUT 1"-8
12	1	McMaster#91104A049 OR EQUIV	GRADE 8 ZINC YELLOW PLATED STEEL SPLIT LOCK WASHER FOR 1" SCREW X 1.024" ID X 1.656" OD.
13	3	McMaster#90273A835 OR EQUIV.	ZINC PLATED STEEL PHILLIPS FLAT HEAD SCREW #10-32 X 1-1/4" LG. X 82° CSK.
14	3	McMaster#90480A195 OR EQUIV	ZINC PLATED STEEL HEX NUT #10-32 X 1/8" HEIGHT
15	3	McMaster#91090A126 OR EQUIV	ZINC PLATED STEEL OVERSIZED WASHER FOR #10 SCREW 0.203" ID X 0.75" OD
16	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
17	A/R	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.



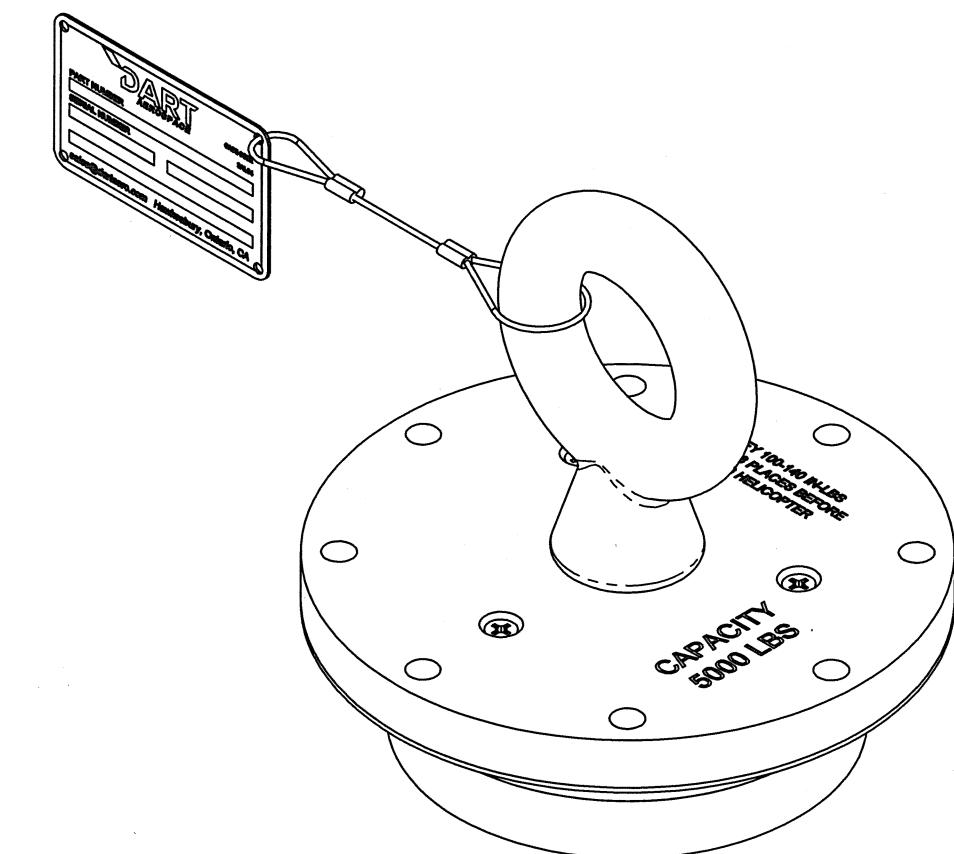
SECTION A-A

RBT400206 HOISTING PLATE

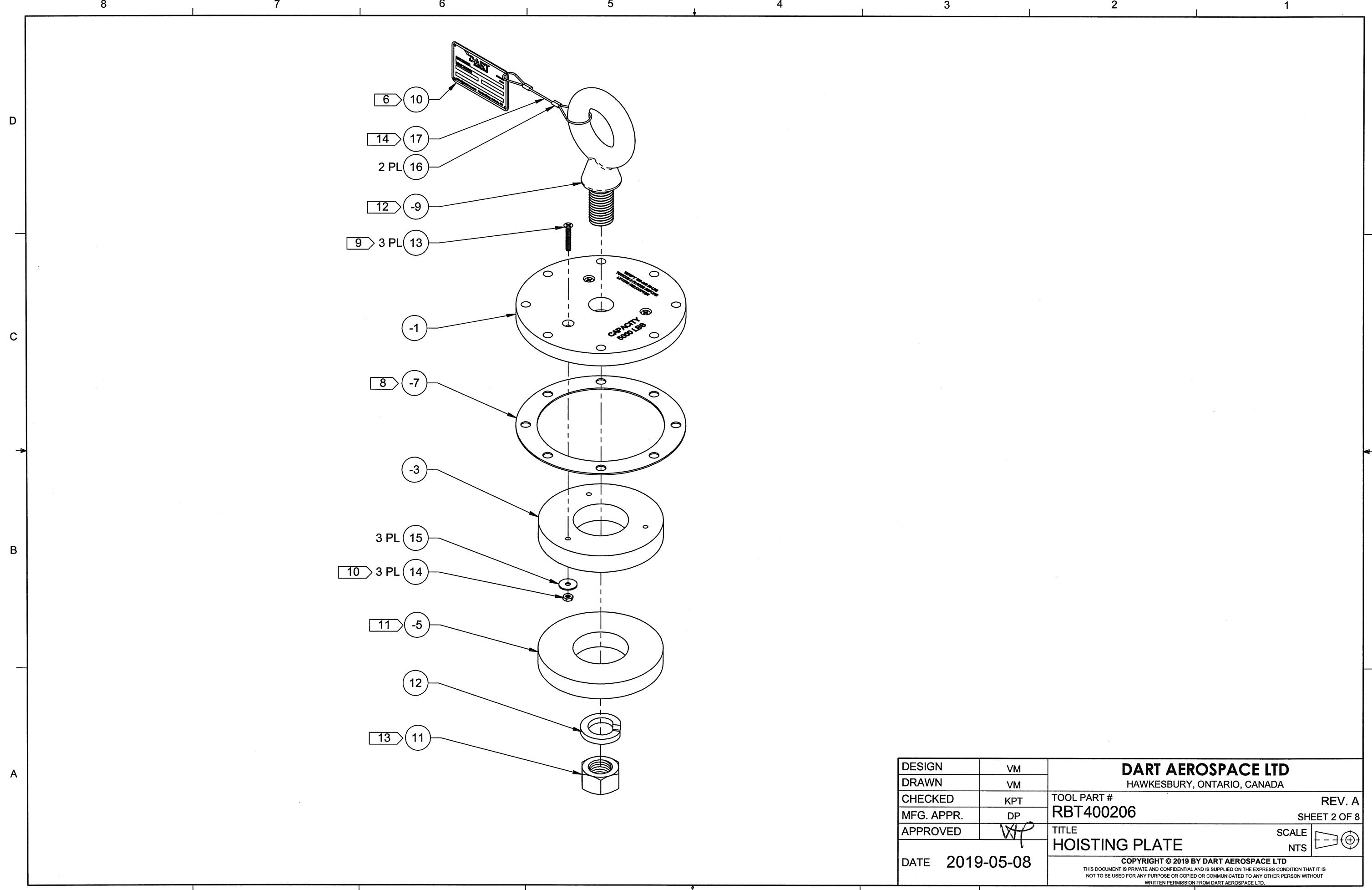
15

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 5000 LBS" ON THE DART PLACARD WHERE INDICATED
 7) ASSEMBLE AS SHOWN
 8) ASSEMBLE ITEM -7 ADHESIVE SIDE ON ITEM -1 AS SHOWN, AND CUT EXCESS IF NECESSARY
 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 13 THEN ASSEMBLE WITH ITEM 14, AND REMOVE EXCESS
 10) INSTALL ITEM 14 HAND TIGHT
 11) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -5 AND ITEM -3, AND REMOVE EXCESS
 12) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM -9 THEN ASSEMBLE WITH ITEM 11, AND REMOVE EXCESS
 13) TORQUE ITEM 11 TO 360-462 FT-LBS
 14) ASSEMBLED LANYARD LENGTH MUST BE 4" +/- 1"
 15) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



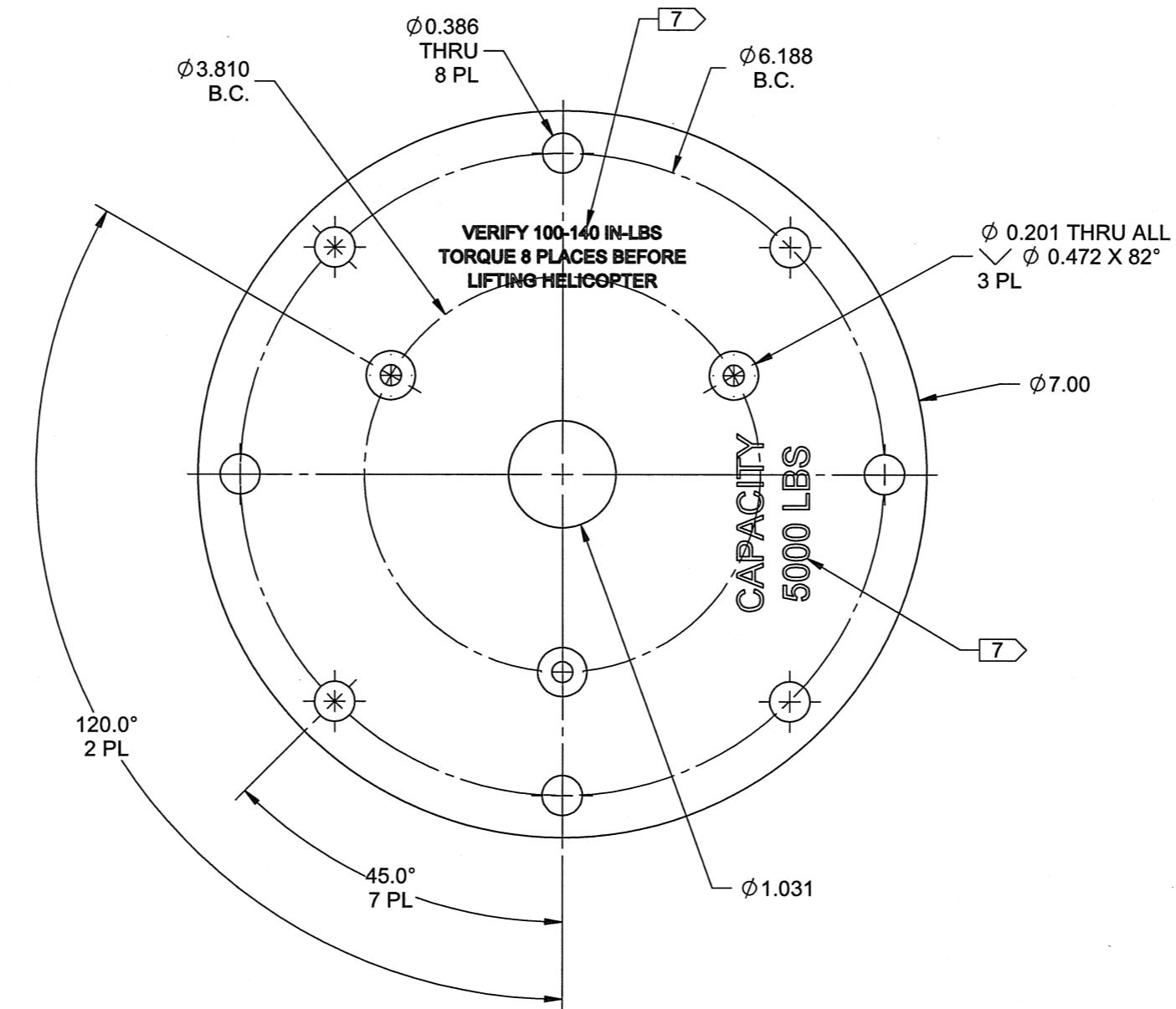
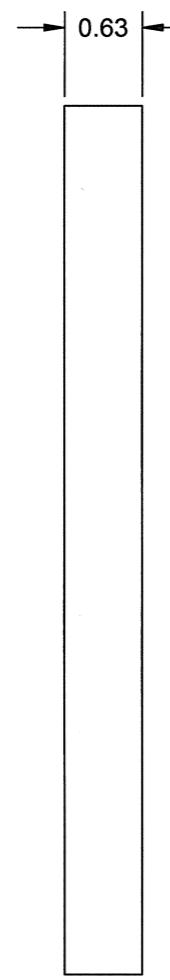
A	SEE PREVIOUS PDF's FOR OLDER REV TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -1 DIMENSION .625 CHANGED FOR 0.63, MATERIAL 1018 FINISH CAD PLATE CHANGED FOR 1018/1020/1025 CR FINSH ZINC PLATE YELLOW TYPE 2, DIMENSION 8X .375 CHANGED FOR CLEARANCE HOLES 8 PL 0.386" ITEM -3 MATERIAL WOOD CHANGED FOR UHMW, DIMENSION 5.150 CHANGED FOR 5.15, DIMENSION 2.281 CHANGED FOR 2.28 ITEM -5 MATERIAL RUBBER CHANGED FOR McMaster#1370N21 ITEM -7 MATERIAL RUBBER CHANGED FOR McMaster#1374N23, DIMENSION 8X .375 CHANGED FOR 8 PL 0.406", DIMENSION .063 CHANGED FOR 0.06 REF ITEM -9 MCMASTER#3014T55 CHANGED FOR McMaster#3014T156	19-671	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD <small>HAWKESBURY, ONTARIO, CANADA</small>	
DRAWN	VM		
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED	WY		
DATE	2019-05-08		
TOOL PART #		REV. A	
RBT400206		SHEET 1 OF 8	
TITLE		SCALE	
HOISTING PLATE		NTS	
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



8 7 6 5 4 3 2 1

D

D

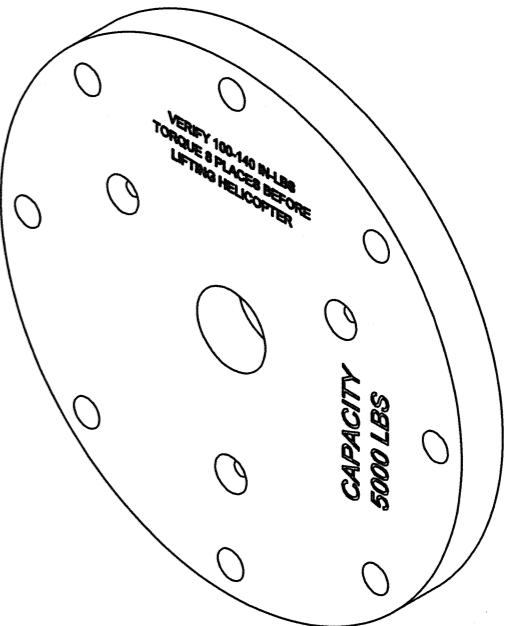


RBT400206-1 PLATE

NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05"
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN, AND FILL WITH BLACK INK

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VM	
CHECKED	KPT	TOOL PART #
MFG. APPR.	DP	RBT400206
APPROVED	WJ	REV. A SHEET 3 OF 8
DATE	2019-05-08	TITLE HOISTING PLATE
		SCALE NTS
		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



8

7

6

5

4

3

2

1

A

D

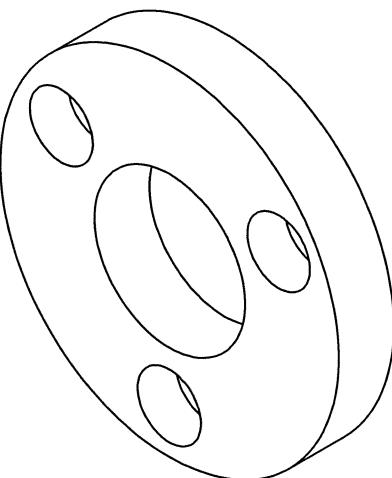
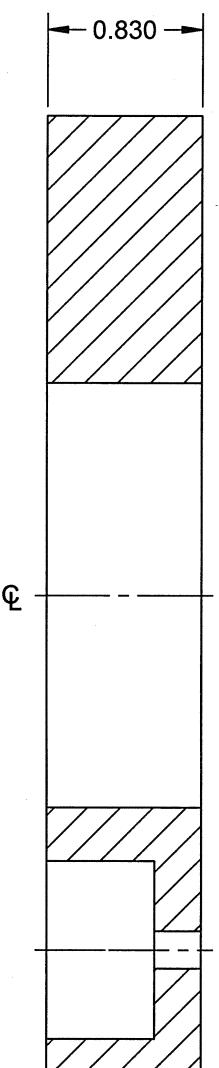
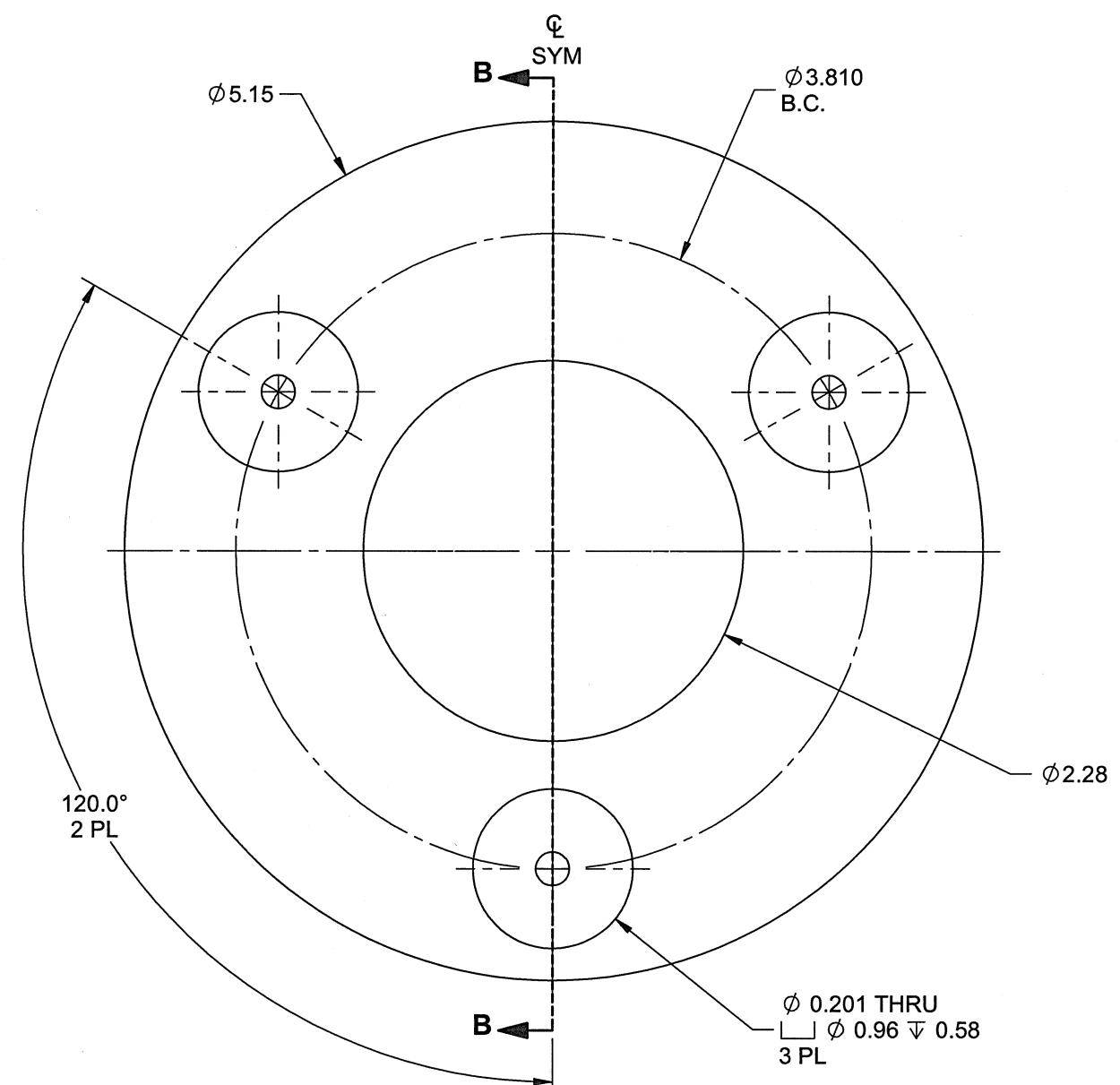
C

B

A

8 7 6 5 4 3 2 1

D



B

C

D

A

NOTES:

- 1) MATERIAL: UHMW
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = \pm 0.1"$ / $\pm 1^\circ$
 $X.XX = \pm 0.01"$ / $\pm 0.5^\circ$
 $X.XXX = \pm 0.005"$ / $\pm 0.1^\circ$
 $X.XXXX = \pm 0.0005"$ / $\pm 0.05^\circ$
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VM	
CHECKED	KPT	
MFG. APPR.	DP	
APPROVED		
DATE	2019-05-08	
TOOL PART #	RBT400206	REV. A
TITLE	HOISTING PLATE	SHEET 4 OF 8
SCALE	NTS	
COPRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

D

D

C

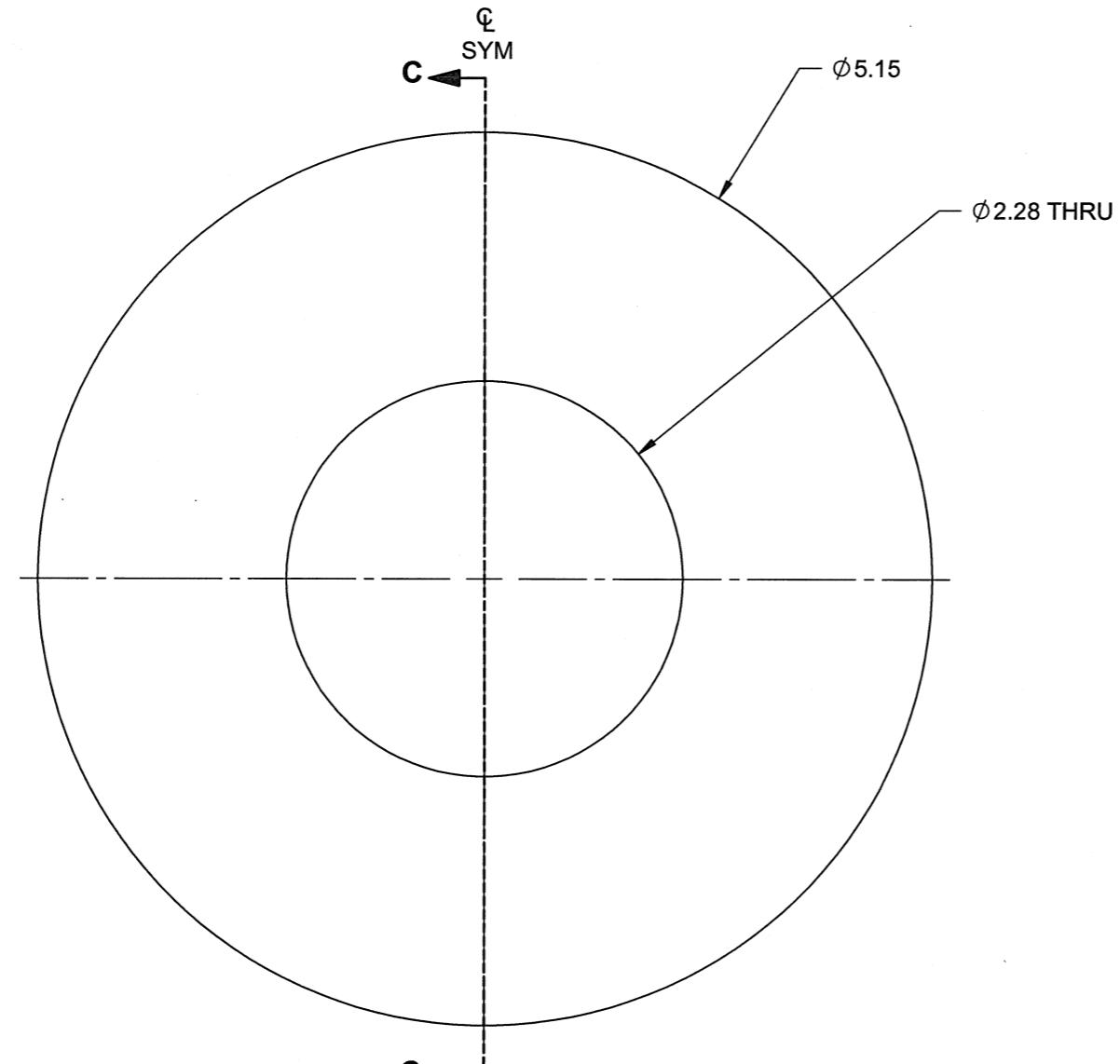
C

B

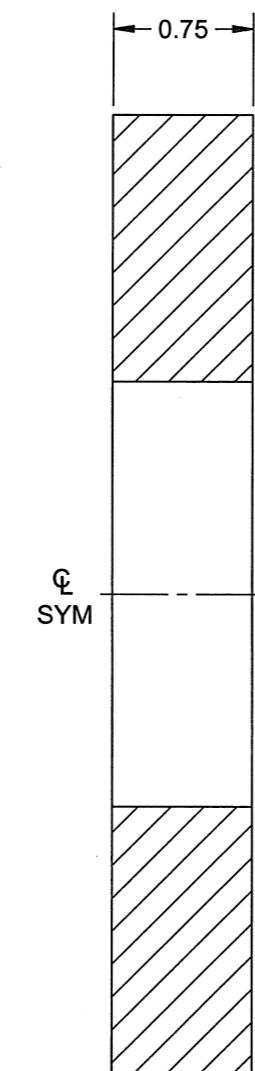
B

A

A



RBT400206-5 SPACER 2



SECTION C-C

NOTES:

1) MATERIAL: McMaster#1370N21 OR EQUIV (MULTIPURPOSE NEOPRENE RUBBER 50A DURO 6" X 6" X 3/4" THK)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DP	RBT400206	SHEET 5 OF 8
APPROVED		TITLE HOISTING PLATE	SCALE NTS
DATE	2019-05-08	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

C

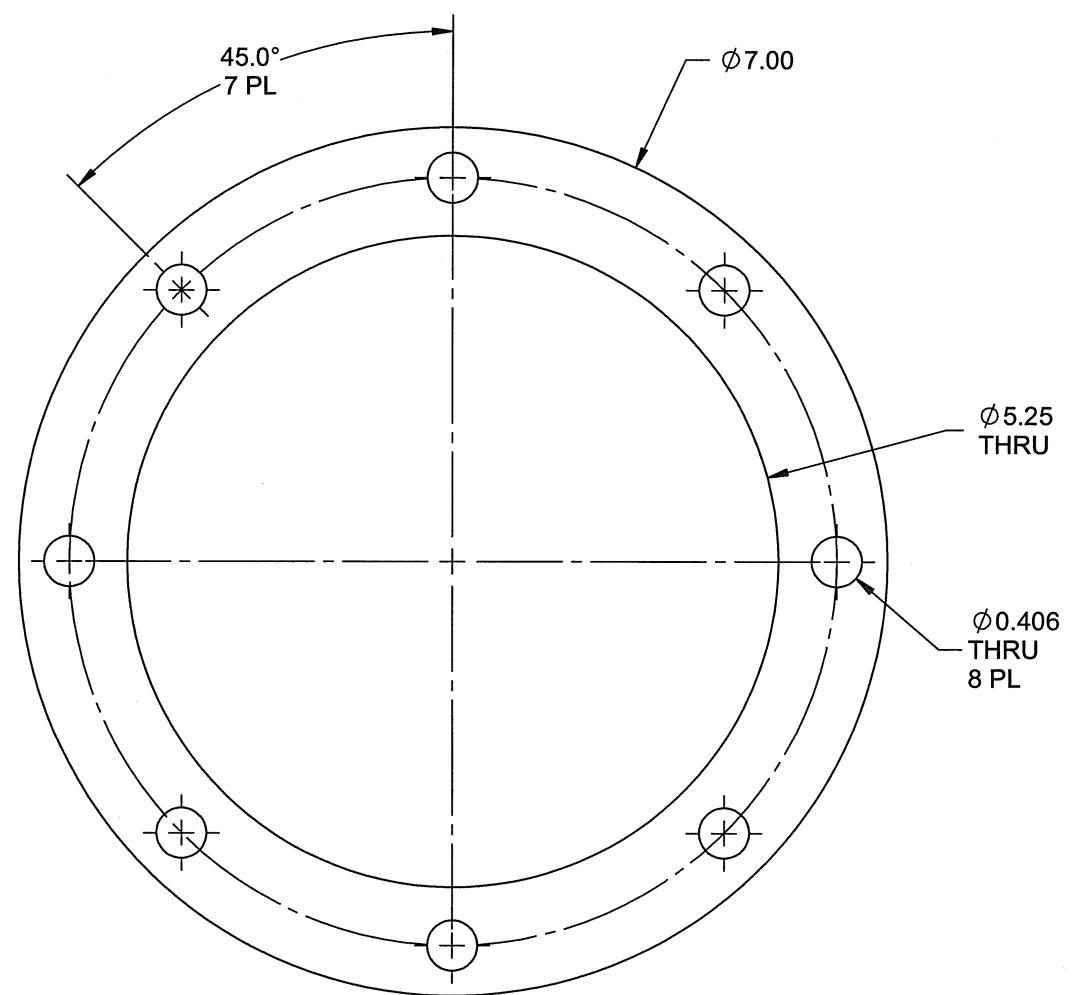
C

B

B

A

A



RBT400206-7 GASKET

NOTES:

1) MATERIAL: McMaster#1374N23 OR EQUIV. (MULTIPURPOSE NEOPRENE RUBBER SHEET ADHESIVE-BACK 50A DURO 12" X 12" X 1/16" THK.)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$

$X.XX = +/- 0.01"$ / $+/- 0.5^\circ$

$X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$

$X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VM	
CHECKED	KPT	
MFG. APPR.	DP	
APPROVED	WJP	
TOOL PART #	RBT400206	
DATE	2019-05-08	

REV. A
SHEET 6 OF 8

TITLE
SCALE
NTS

HOISTING PLATE

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

D

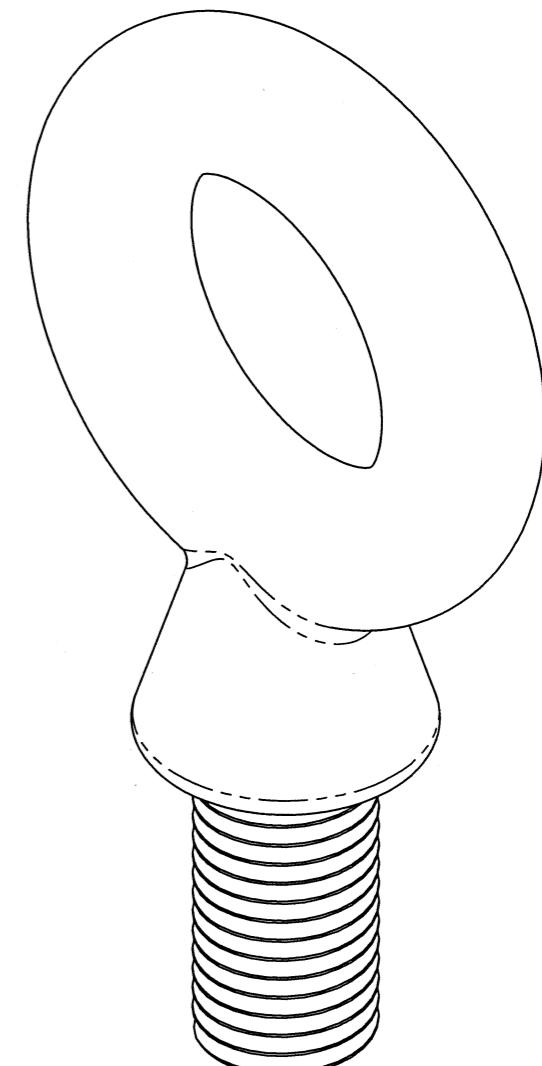
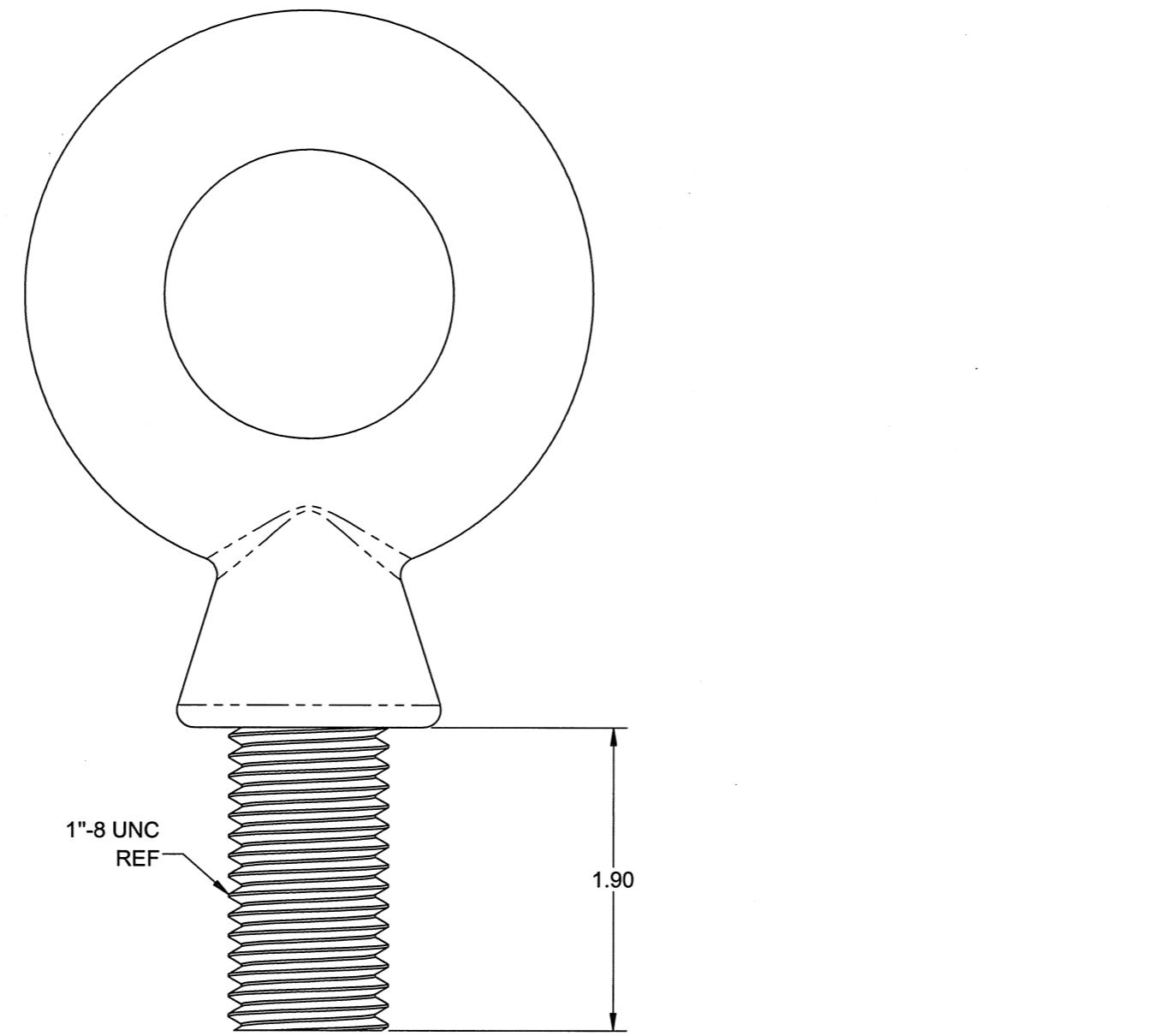
D

C

C

B

B



RBT400206-9 EYE BOLT MODIFIED

8

NOTES:

1) MATERIAL: McMaster#3014T156 OR EQUIV. (ZINC PLATED STEEL EYEBOLT WITH SHOULDER 9000 LBS LIFTING CAPACITY 1"-8 X 2-1/2" THREAD LENGTH)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) APPLY RUST INHIBITOR LPS 3 ON BARE SURFACES

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBT400206 REV. A SHEET 7 OF 8
DRAWN	VM	
CHECKED	KPT	
MFG. APPR.	DP	
APPROVED		
DATE	2019-05-08	

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

5

4

3

2

1

8

7

6

5

4

3

2

1

D

D

C

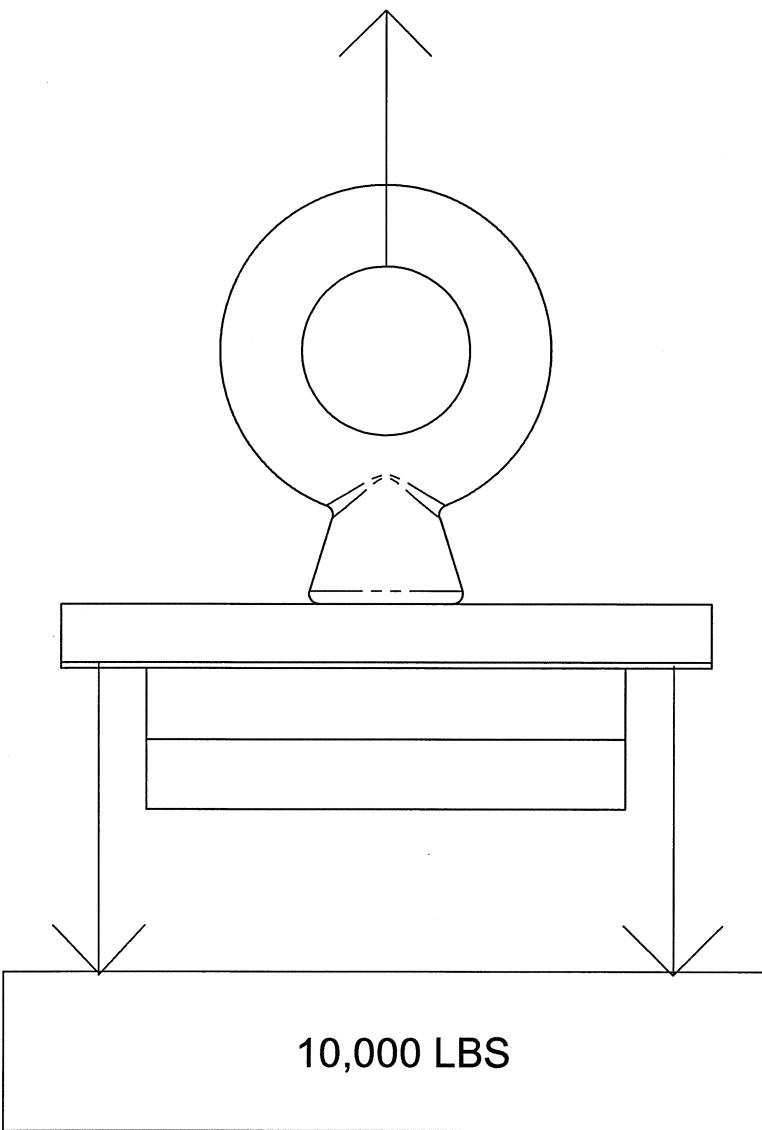
C

B

B

A

A



INSPECTION & TESTING PROCEDURE FOR THE RBT400206,
HOISTING PLATE.
THIS HOISTING TOOL SHOULD BE INSPECTED BEFORE AND AFTER
EACH USE.

**REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED
OF DAMAGE BEFORE USING!**

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE HOISTING TOOL ON AN OVERHEAD LIFTING DEVICE. ATTACH HOISTING TOOL TO AN APPROPRIATE TEST WEIGHT TEST OF 10,000 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGE.
3. REMOVE WEIGHT AND RE-INSPECT, CHECKING FOR ANY CRACKS, DEFLECTION, DISTORTION OR DAMAGE.

INSPECTOR: _____

TESTER: _____

S.N.: _____

DATE: _____

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	VM	
CHECKED	KPT	
MFG. APPR.	DP	
APPROVED	VH	
DATE	2019-05-08	
TOOL PART #	RBT400206	REV. A
TITLE	HOISTING PLATE	SHEET 8 OF 8
SCALE	N.T.S.	
COPRIGHT © 2019 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		